

Work Order ID 121238-2

121238

Page 1

June-18-14 1:58:14 PM

Item ID: D3463-7

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Drag Arm

Start Date: 6/18/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/18/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-06-18

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00
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100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut to 13.875"
2-Deburr
3-Bend end as per dwg D3463

20x

DAS
28
9-89

OCT 20 2014

DAS
30
9-89

DAS
38
9-89

110	QC5- Inspect part completeness to step on W/O	0.00
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110

QC

Memo

0.00

Quality Control

20 DAS
51
9-89

14/10/20

120		0.00
-----	--	------

120

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-Mill as per dwg D3463
2-Drill hole & ream to 0.4385" as per dwg D3463
3-Deburr

20

0

20.1

DAS
37
9-89

14/10/20

Page 2

Grind .450" rad

DAS
37
9-89

14/10/25

DAS
20
~~9-88~~

14-10-24

DAS
36
9-89

Work Order ID 121238

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June-18-14 1:58:14 PM

Item ID: D3463-7 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Drag Arm
Start Date: 6/18/14 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 6/18/14 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00				(10)			DAS 38 9-89

160

QC

Memo

Quality Control

OCT 27 2014

170 Identify as per dwg & Stock Location: 628002 0.00

170

Packaging

Memo

Packaging

DAS
26
9-89

OCT 27 2014

180 QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

Quality Control

14/10/28

mf
14-10-28

Picklist Print

June-18-14 1:58:18 PM

Page 1

Work Order ID: 121238

121238

Parent Item: D3463-7

D3463-7

Parent Item Name: Drag Arm

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.750W.120		Purchased	No			100	f	41.7500	1.15625	25			
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M304TR0 750W 120

304 ss round tube .750 x .120w

DAS
22
22

OCT 20 2014

Location

Loc Qty

Loc Code

MAT017

41.75

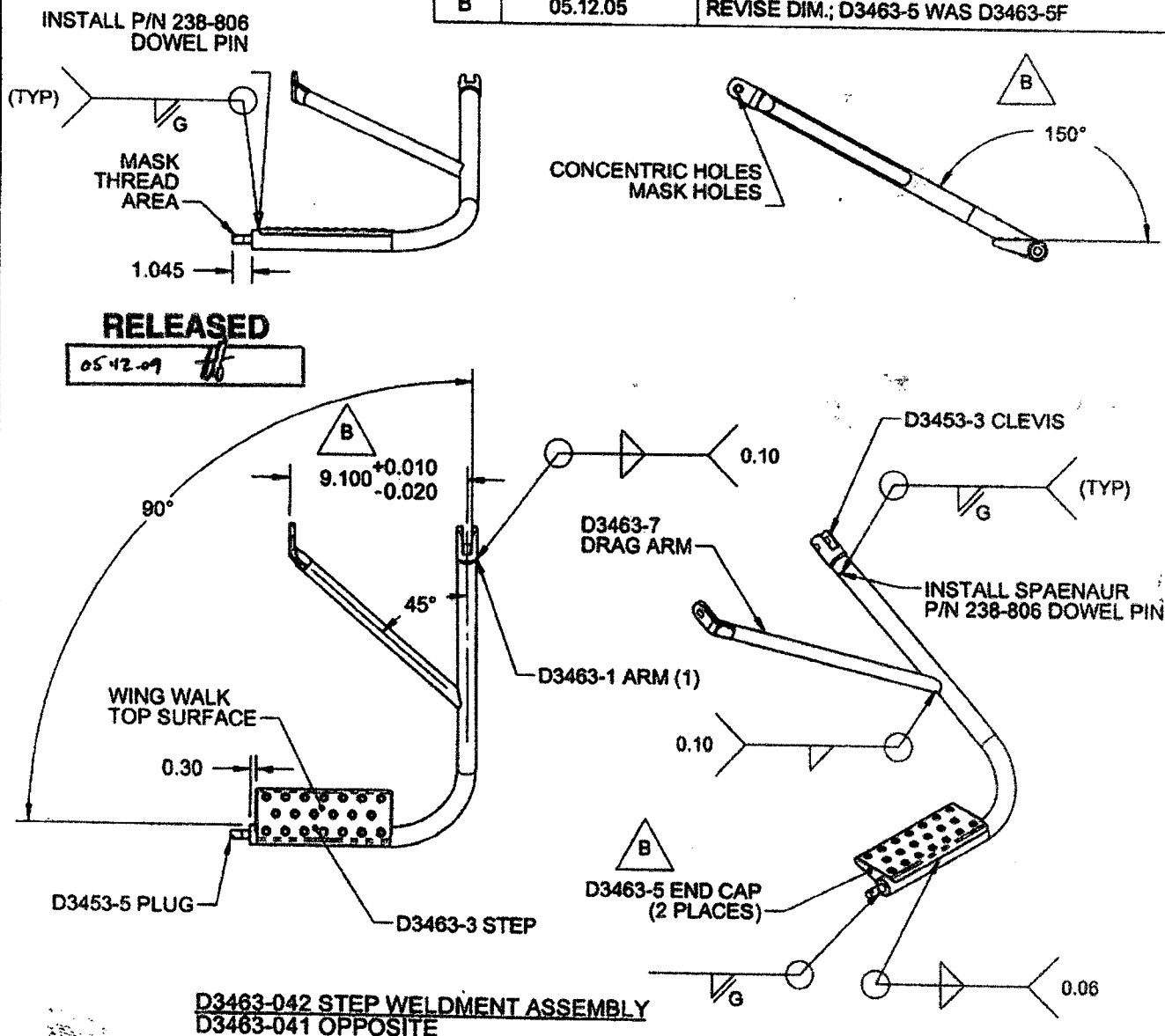
125656

41.75

130071



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT SCALE 1:8		
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 006 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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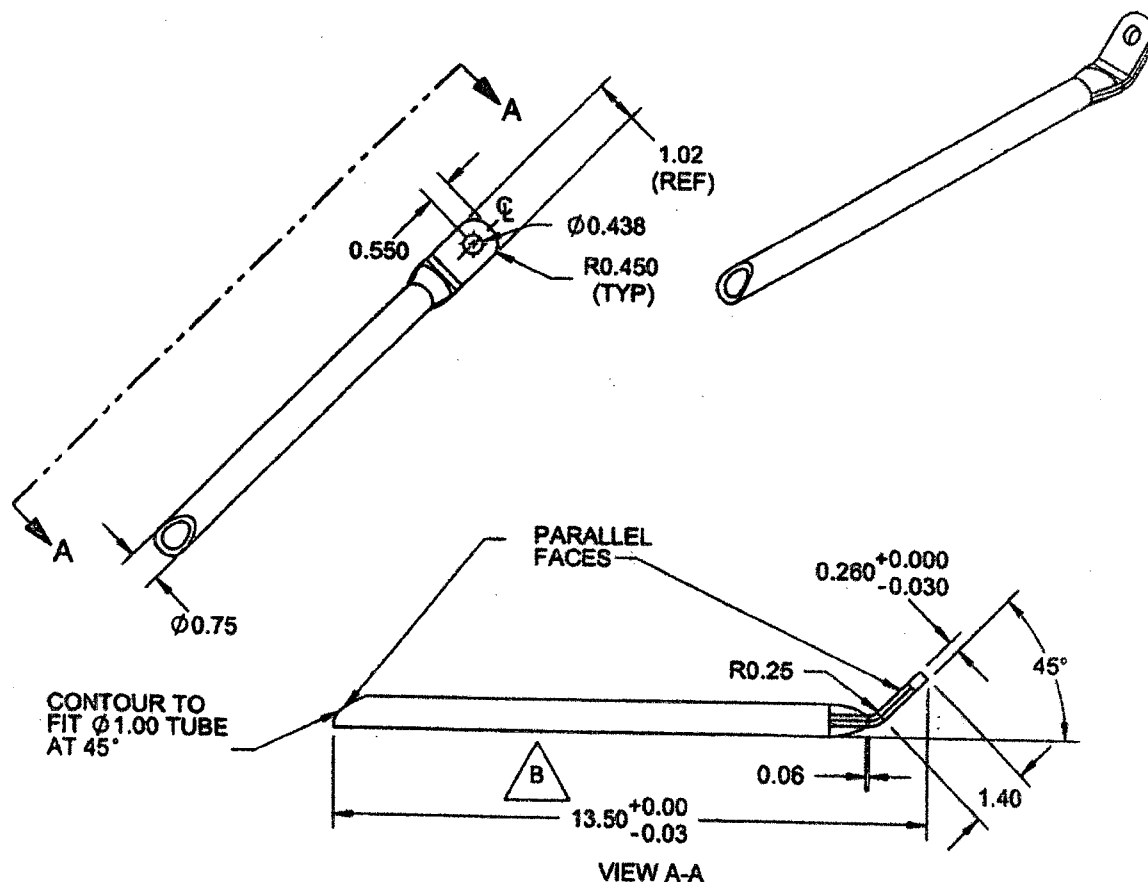
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #10	APPROVED #10	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:1

RELEASED

05.12.09



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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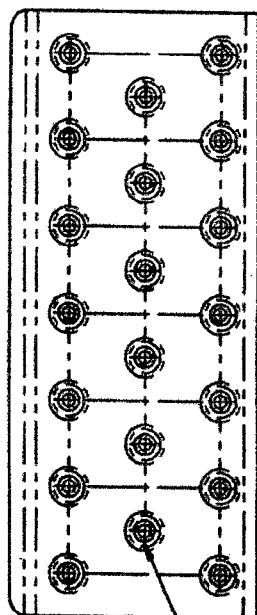
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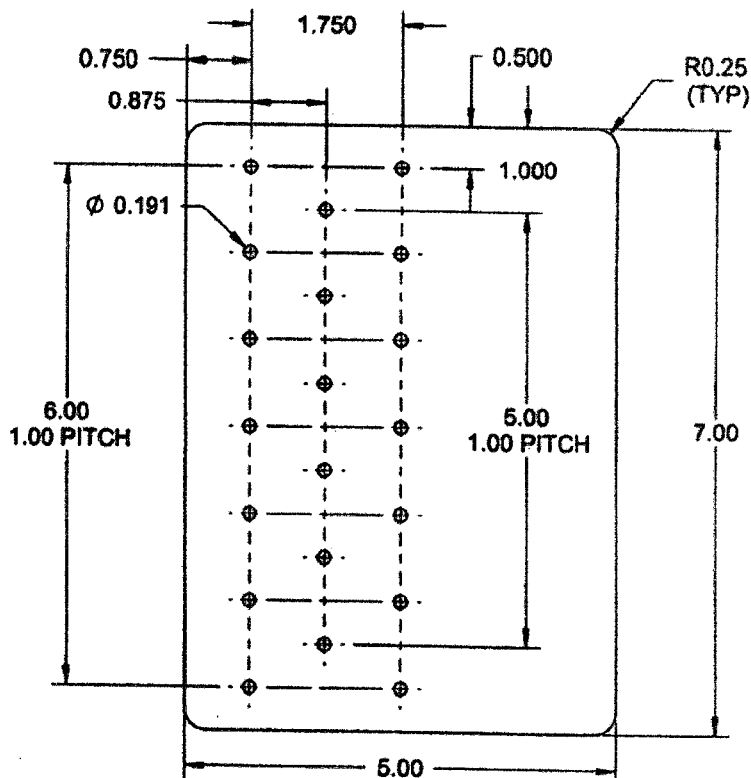
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

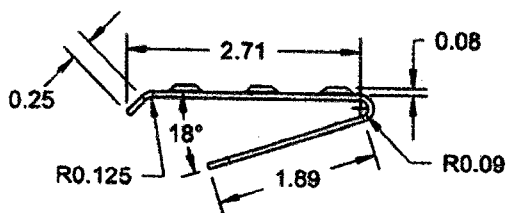
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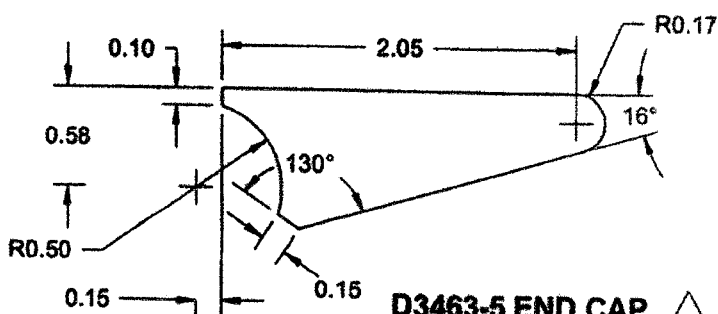
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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FIRST ARTICLE INSPECTION CHECKLIST

DAS		DAS		Preliminary Approval:	
37		20			
9-89		9-89		Date:	
Measured by: J.C. - L.		Audited by:			
Date: 14/10/22		Date: 14-10-24			

10.04.15